

# Work Order ID 83839

\*83839\*

Page 1

Thursday, April 26, 2012 1:08:44 PM

Item ID: D4577-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Rear Access Panel

Start Date: 4/26/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 5/3/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

*mrf*

Date: 12-04-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4577

B

(4)

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

6061 .125

1312-4-27

110

0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1312-4-27

120

0.00

\*120\*

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*Scrub 130*

(74)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83839

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Thursday, April 26, 2012 1:08:44 PM

Item ID: D4577-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Rear Access Panel  
 Start Date: 4/26/2012 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 5/3/2012 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
*150*									
HandFinish	Memo	0.00							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
*160*									
QC	Memo	0.00							
Quality Control									
170	Gloss Grey (4.3.5.15) per QSI 005 4.3	0.00							
*170*									
Powdercoat	Memo	0.00							
Powder Coating	***TOP SIDE ONLY***								

START TIME: 1:50  
 OVEN TEMPERATURE: 320°F  
 FINISH TIME: 2:20

M 118533

4X 12-4-30

4X 12/5/08

4X 12/5/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 83839****\*83839\***

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Thursday, April 26, 2012 1:08:44 PM

Item ID: D4577-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rear Access Panel

Start Date: 4/26/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 5/3/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180 QC3- Inspect Part Finish

0.00

**\*180\***

QC Memo

0.00

Quality Control

1/1  $\phi$  BL 12.4.8.190 Identify as per dwg & Stock Location: **237A**

0.00

**\*190\***

Packaging Memo

0.00

Packaging

(42) 12/5/980

200 QC21- Final Inspection - Work Order Release

0.00

**\*200\***

QC Memo

0.00

Quality Control

12/5/980  
ME  
12-05-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 26, 2012 1:08:44 PM

Page 1

Work Order ID: 83839

Parent Item: D4577-1

Parent Item Name: Rear Access Panel

Start Date: 4/26/2012

Required Date: 5/3/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC  
DWG REV.B DD VERF:EC

IPP REV:B 12.04.25 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	113.1500	0.84	3.5368421			

Location

Loc Qty

Loc Code

MAT021

113.15

120218

3.21

121473

109.94

121473

B124-27  
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

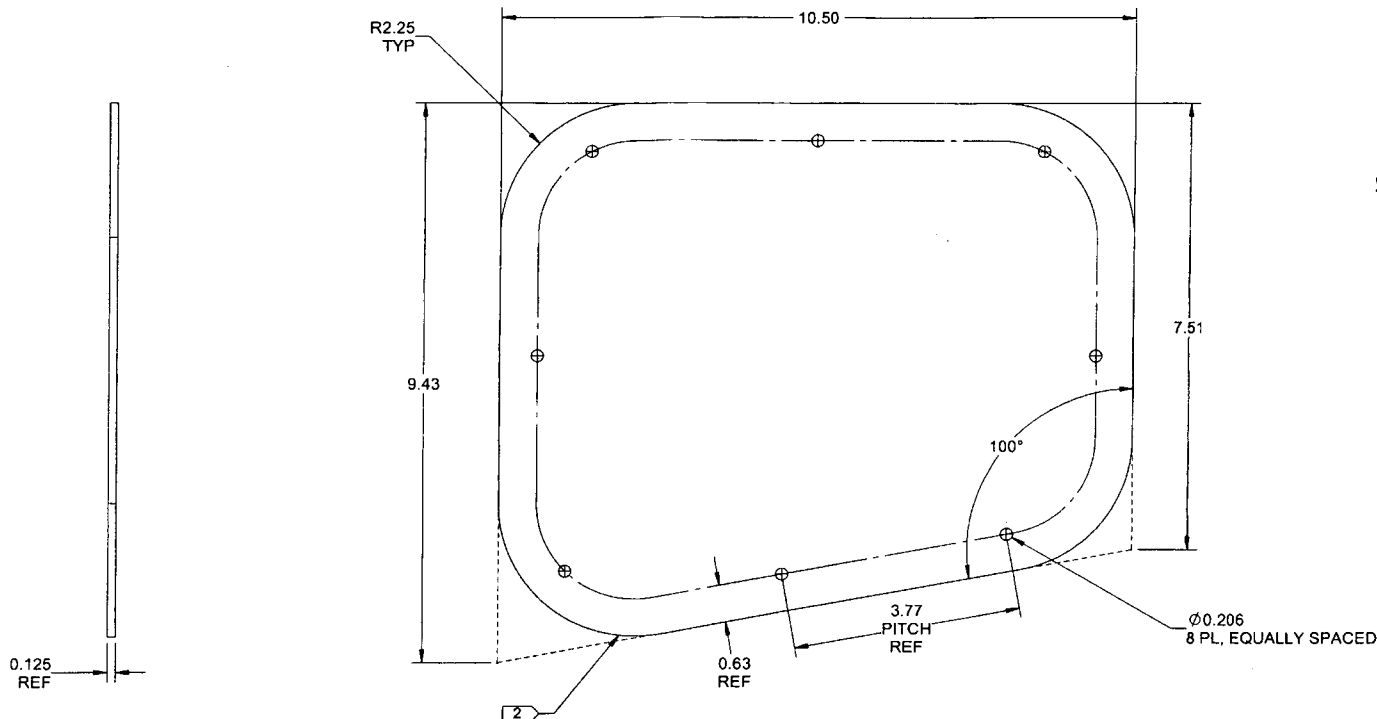
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries







**D4577-1 REAR ACCESS PANEL**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3 TOP SIDE ONLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.03 lbs

DESIGN	BC	<b>DART AEROSPACE LTD</b>	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BE	DRAWING NO.	REV. B
MFG. APPR.	BE	<b>D4577</b>	SHEET 2 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	<b>ACCESS PANEL</b>	NTS
DATE	12.03.30	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

# 82839

RELEASED  
2012-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries